

Work Order ID 61150

Tuesday, August 10, 2010 8:38:02 AM

Page 1

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 8/11/2010 Start Qty: 10.00

Required Date: 9/15/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mp Date: 10-8-10 Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3272	Rev B
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

704A 41 640 011

8/10/2015

I put Rep Labels on steps
8/10/2015

Handwritten: BG 10-9-14

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod 112860
114877

3-Grind End Plate flush

Handwritten: 10.08.26

Handwritten: 10 of

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

③ PD 10.08.26

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/08/26

X10
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JH 10/08/31

X10 RH

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BR 10-8-31.

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

K 10.09.08

10 P

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M112260

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 10.09.09

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/09/09

x10
RH

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BF 10-9-13

D

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 114841</i>	0.00 <i>BR 10-9-14</i>				<i>10</i>			
	Memo START TIME: <i>9:40</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:10</i>	0.00							
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115028</i>	0.00 <i>=> 10 10/09/11</i>				<i>10</i> <i>LH</i>	<i>01</i>		
	Memo	0.00							
240 QC Quality Control	QC3- Inspect Part Finish	0.00				<i>M</i>	<i>10</i>	<i>02</i>	<i>11</i> <i>10</i>
	Memo	0.00							

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NOTE: Date & initial all entries

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Tuesday, August 10, 2010 8:38:02 AM

Accept

**Setup Start**[illegible]

Stop

[REDACTED]

[illegible]**Cust Item ID:**

Start Date: 8/11/2010 **Start Qty:** 10.00

Required Date: 9/15/2010 **Req'd Qty:** 10.00

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

Abstract

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____

Date:

**Insp.
Stamp**

SECRET

Packaging

Memo

0.00

Packaging



QC

Memo

0.00

Quality Control

0.00

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

2. The second step is to define the requirements for the system. This includes identifying the functional requirements, performance requirements, and security requirements.

3. The third step is to design the system architecture. This includes determining the overall structure of the system, the components, and the data flow.

4. The fourth step is to implement the system. This includes developing the code, configuring the hardware, and testing the system.

5. The fifth step is to maintain the system. This includes monitoring the system performance, updating the software, and addressing any issues that arise.

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/09/10
MF
10-9-16

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Tuesday, August 10, 2010 8:38:01 AM




Page 1

[illegible][illegible]**Required Date: 9/15/2010**

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC
 fixe route seq in bom DD 10.04.28 verified by:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-35A 		Purchased	No			250	Each	113.0000	2	20		10/9/14	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>					
				ST353				113					
				115016				13					
				115108				100					
AN4-13A 		Purchased	No			250	Each	894.0000	8	80		10/9/14	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>					
				ST357				394					
				115108				394					
				ST358				500					
				115159				500					
AN5-36A 		Purchased	No			250	Each	173.0000	2	20		10/9/14	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>					
				ST341				173					
				114292				5					
				114941				168					

W/O:		WORK ORDER CHANGES					
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Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD10 NAS1149D0363J Purchased No



Washer

250 Each 6.0000 4 '40



M115622 10/9/148

Location

Loc Qty

Loc Code

ST
107715

6
6

AN960JD416 NAS1149D0463J Purchased No



Washer

250 Each 0.0000 16 160



M115000 10/9/148

AN960JD516 NAS1149D0563J Purchased No



Washer

250 Each 34.0000 4 40



M114742 10/9/148

Location

Loc Qty

Loc Code

ST
103694
107534
109287

34
18
12
4

D2230-3 Manufactured No



Lug

250 Each 109.0000 4 40



10/9/148

Location

Loc Qty

Loc Code

ST476
55452
59418
60191

109
2
8
99

8
34

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Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250

Each

189.0000

2

20



Bushing



10/9/148

Location

Loc Qty

Loc Code

ST019

187

60193

73

60772

114

ST020

2

56892

1

57829

1

D2856-400

Manufactured No

250

f

340.9788

0.6

6



Abraison Strip



10/9/148

Location

Loc Qty

Loc Code

ST403

340.9788421

56626

124.978842

59920

216

D3065-041

Manufactured No

180

Each

6.0000

1

10



Step Leg Assembly Hi



10.09.07

Location

Loc Qty

Loc Code

WA

360200

6

58536

4

59678

2

D3066-1

Manufactured No

180

Each

89.0000

2

20



Spacer



10.09.07

Location

Loc Qty

Loc Code

WA

89

58540

23

60194

66

20

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Start Date: 8/11/2010


Required Date: 9/15/2010


Start Qty: 10.00


Required Qty: 10.00

D3067-1	Manufactured	No	110	Each	132.0000	1	10	
								
End Plate								<i>10-08-26</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	132				
			<u>60141</u>	132			<i>10</i>	
D3067-1	Manufactured	No		180	Each	132.0000	1	10
								
End Plate								<i>10-08-07</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	132				
			<u>60141</u>	132			<i>10</i>	
D3219-1	Manufactured	No		180	Each	27.0000	2	20
								
Plate								<i>10-08-26</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	27				
			<u>59597</u>	27			<i>20</i>	
D3235-1	Manufactured	No		250	Each	93.0000	2	20
								
Mounting Lug								<i>10/9/14</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST471	93				
			59125	13				
			<u>60195</u>	40			<i>20</i>	
			60490	40				
D3272-1	Manufactured	No		110	Each	0.0000	1	10
								
Step								<i>361148 10-08-26</i>

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250 Each

55.0000

1

10



Support Assembly

Location

Loc Qty

Loc Code

ST471

55

59633

15

60201

40

MS20600-AD4W4

Purchased

No

180

Each

179.0000

16

160



Rivets

Location

Loc Qty

Loc Code

ST321

115573

179

113368

62

114181

11

114718

2

114935

104

MS21042L3

Purchased

No

250

Each

2,426.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

2426

114523

115

114718

311

114784

2000

Tuesday, August 10, 2010 8:38:01 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, August 10, 2010 8:38:01 AM

Work Order ID: 61150



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,263.000

8

80



10/9/14

Nut

Location

Loc Qty

Loc Code

ST300

3263

113422

68

114523

28

114718

16

114784

1151

115108

2000

80

MS21042L5

Purchased

No

250

Each

738.0000

2

20



10/9/12/15

Nut

Location

Loc Qty

Loc Code

ST139

238

114813

238

ST300

500

115156

500

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

#61150

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

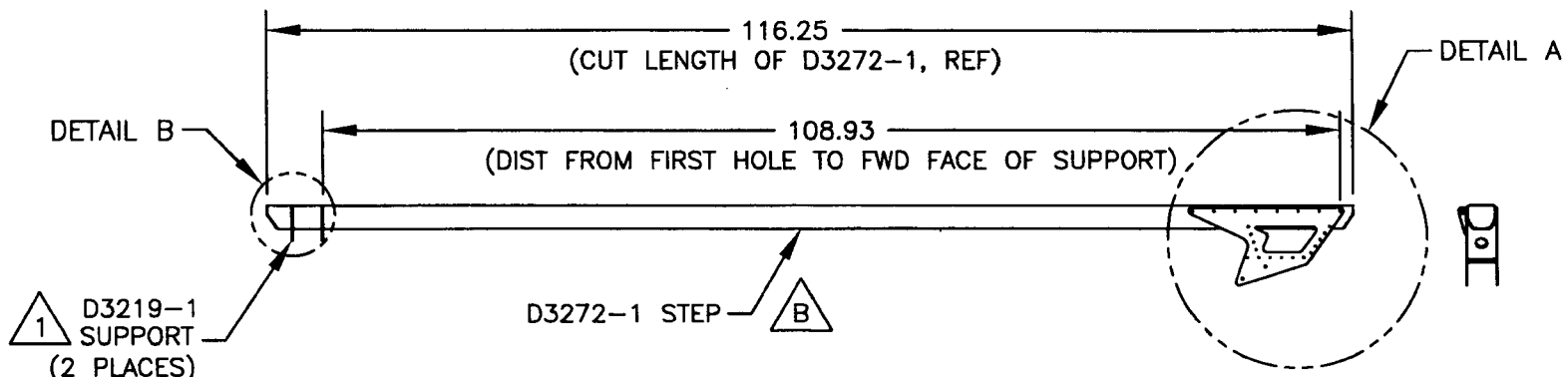
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

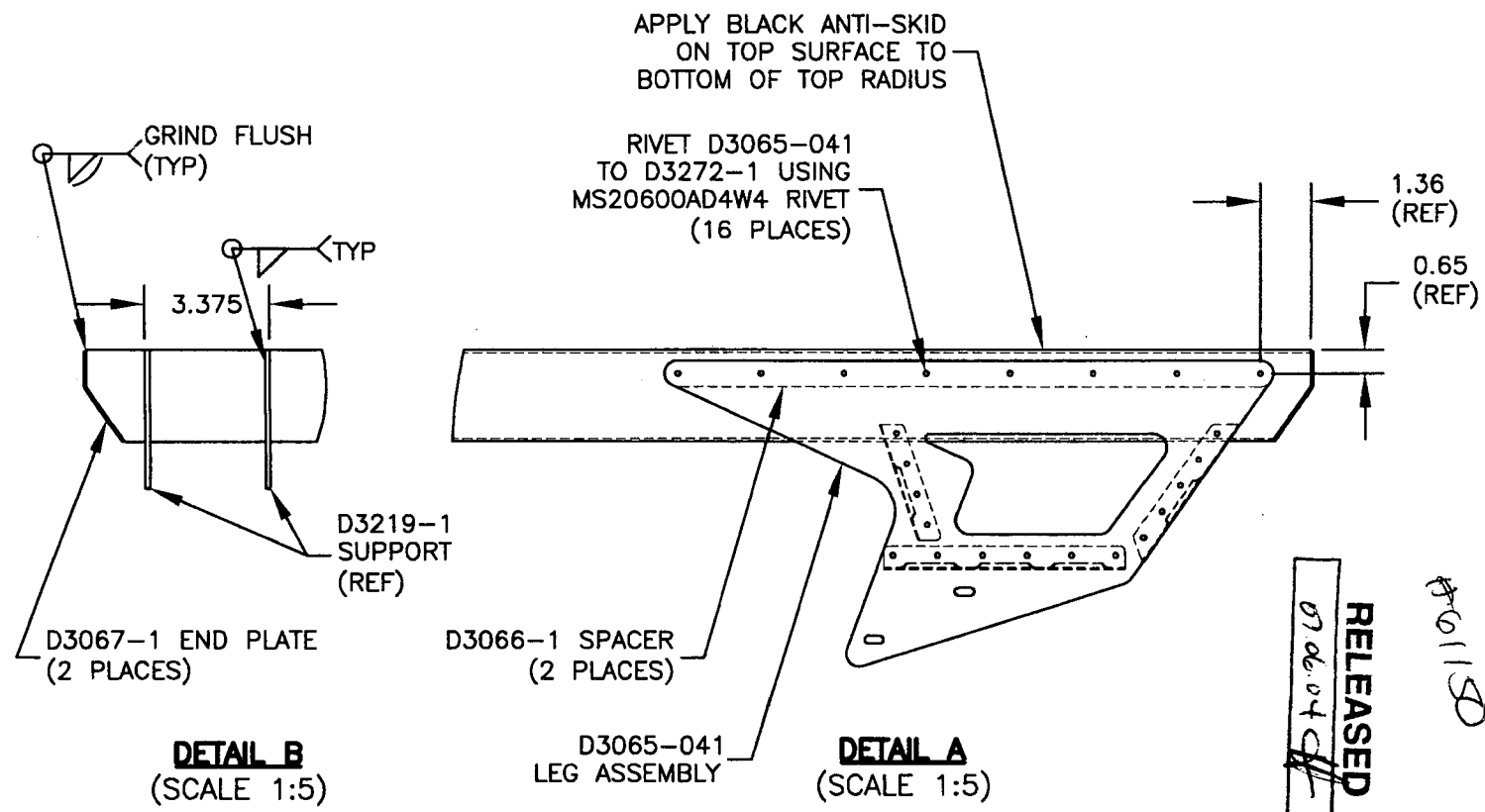
DART

DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE	DATE	TITLE	SCALE
07.05.18	07.05.18	STEP ASSEMBLY, HI LONG	1:20

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

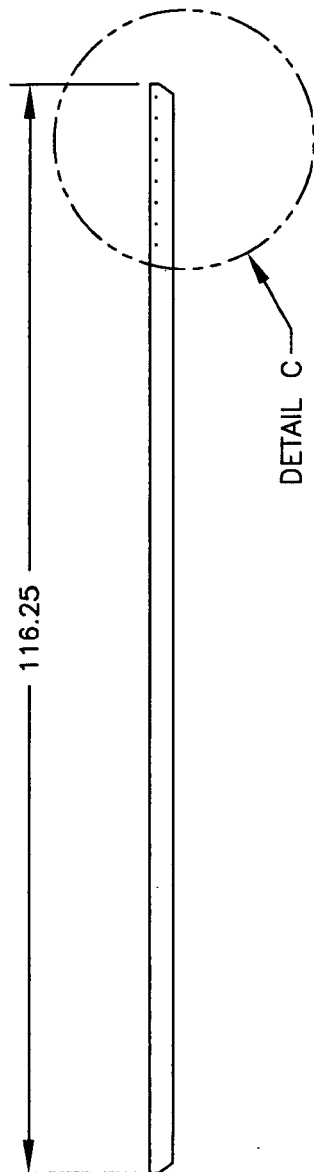
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



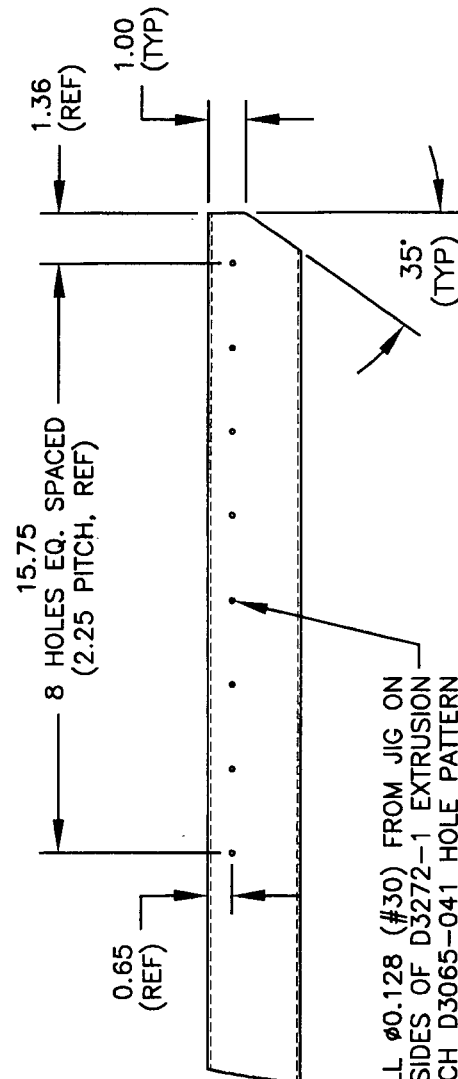
DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

#61160

RELEASED

07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.